

Date: Wednesday, 2/15/2006 3:46:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 25831  
 Estimate Number : 10531  
 P.O. Number : N/A Part Number : D2572  
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2572 REV DE 06.02.16  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : DE  
 Previous Run : 25830 Material : N/A  
 Due Date : 3/15/2006 Qty: 15 Um: Each  
 Written By : See comment below  
 Checked & Approved By : 06.02.16  
 Comment : Est: 1 02:40.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: B 24069

(15)

SG. 06/03/13

15

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 25831 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

06.03.22

SG For  
EP 1 FG.

15

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



06.03.22

Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

SG For  
EP 1 J.G.

15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25831

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



06.03.22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En / BG For JG. 15

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 06.03.22 15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06/03/22 (15)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/22 (15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/22 15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 479

DL 06/03/22 (18)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/03/23

u 06.03.23

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25831</b>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.748	1.748		
C	3.495	3.505		3.497	3.497	3.497	3.497		
D	1.745	1.755		1.746	1.746	1.747	1.747		
E	7.990	8.010		7.999	8.000	8.001	8.001		
F	0.490	0.510		0.492	0.490	0.505	0.504		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.497	0.498	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.178	1.178		
K	0.558	0.578		0.569	0.568	0.570	0.569		
L	1.174	1.184		1.177	1.177	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.496	1.496		
N	2.495	2.505		2.495	2.496	2.496	2.497		
O	3.869	3.879		3.872	3.871	3.870	3.871		
P	0.115	0.135		0.125	0.126	0.128	0.128		
Q	0.115	0.135		0.130	0.130	0.130	0.131		
R	0.240	0.260		0.249	0.248	0.249	0.248		
S	0.115	0.135		0.122	0.122	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.248	0.247	0.235	0.235		
W	0.115	0.135		0.122	0.122	0.124	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.362	0.362	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.245	0.247	0.246		
AE	1.375	1.395		1.384	1.388	1.389	1.389		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.236	0.235	0.247	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN 15.6
Date:	06/03/16

Audited by:	BC
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

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C	3.495	3.505		3.500	3.499	3.496	3.495		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.001	8.002	8.002			
F	0.490	0.510		0.501	0.500	0.492	0.492		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.500	0.496	0.497		
J	1.174	1.184		1.176	1.176	1.177	1.177		
K	0.558	0.578		0.568	0.569	0.568	0.567		
L	1.174	1.184		1.176	1.176	1.177	1.177		
M	1.490	1.500		1.495	1.496	1.492	1.493		
N	2.495	2.505		2.497	2.497	2.495	2.498		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.125	0.124	0.128	0.126		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.245	0.244	0.252	0.250		
S	0.115	0.135		0.130	0.129	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.232	0.236		
W	0.115	0.135		0.125	0.124	0.120	0.122		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.245	0.247		
AE	1.375	1.395		1.387	1.388	1.386	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.252	0.250		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	<b>SG</b>
Date:	

Audited by:	<b>BG</b>
Date:	<b>06.03.22</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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B	1.745	1.755		1.745	1.745	1.746	1.745		
C	3.495	3.505		3.497	3.497	3.496	3.495		
D	1.745	1.755		1.745	1.745	1.746	1.745		
E	7.990	8.010		8.003	8.002	8.005	8.005		
F	0.490	0.510		0.492	0.492	0.492	0.492		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.496	0.496	0.496	0.495		
J	1.174	1.184		1.178	1.178	1.177	1.177		
K	0.558	0.578		0.568	0.565	0.567	0.568		
L	1.174	1.184		1.178	1.178	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.494	1.493		
N	2.495	2.505		2.496	2.497	2.496	2.496		
O	3.869	3.879		3.871	3.872	3.873	3.872		
P	0.115	0.135		0.126	0.127	0.128	0.128		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.252	0.253	0.253		
S	0.115	0.135		0.121	0.122	0.120	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.232	0.236	0.236	0.235		
W	0.115	0.135		0.131	0.127	0.124	0.125		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.625	0.624	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.246	0.246	0.249		
AE	1.375	1.395		1.383	1.385	1.389	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.248	0.245		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SP
Date:	06/03/20

Audited by:	36
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25831
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<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

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B	1.745	1.755		1.746	1.745	1.745			
C	3.495	3.505		3.497	3.497	3.500			
D	1.745	1.755		1.746	1.745	1.746			
E	7.990	8.010		8.005	8.007	8.003			
F	0.490	0.510		0.500	0.498	0.500			
G	0.257	0.262	DT8683	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.375	0.375	0.375			
I	0.490	0.510		0.495	0.496	0.495			
J	1.174	1.184		1.176	1.177	1.178			
K	0.558	0.578		0.565	0.568	0.568			
L	1.174	1.184		1.176	1.177	1.177			
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Q	0.115	0.135		0.130	0.130	0.130			
R	0.240	0.260		0.252	0.248	0.252			
S	0.115	0.135		0.118	0.122	0.122			
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U	2.940	2.980		2.960	2.960	2.960			
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Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.360	0.362	0.365			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.624	0.624	0.625			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.244	0.249	0.249			
AE	1.375	1.395		1.385	1.386	1.385			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.260	0.260	0.260			
AH	0.240	0.260		0.248	0.248	0.248			
AI	2.000	2.020		N/A	N/A	N/A			
AJ	0.023	0.043		0.038	0.030	0.030			
Accept/Reject									

Measured by:	EP
Date:	06/03/20

Audited by:	BG
Date:	06.03.22

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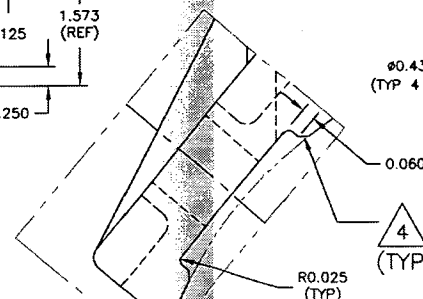
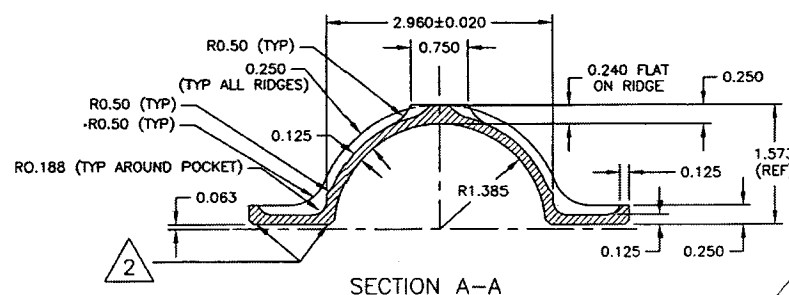
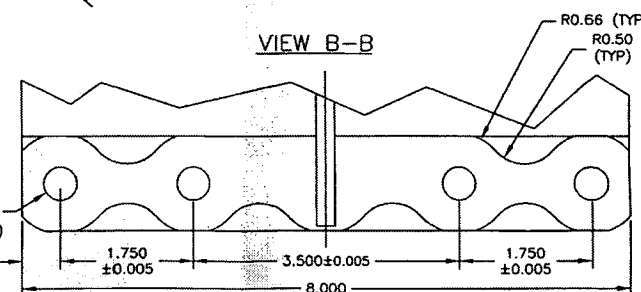
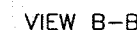


05.12.06





MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		
DS	DRAWN BY PH	<b>DART</b>
CHECKED 	APPROVED 	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED		DRAWING NO.
05.07.13		D2572
DATE		TITLE
05.07.13		INNER FWD SADDLE
		SCALE
		2

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NO. 25831